

Work Order ID 96486

January-28-13 2:20:22 PM

96486

Page 1

Item ID: D4020-11

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: End Mesh, Basket

Start Date: 1/28/13 Start Qty: 6.00

6

Cust Item ID:

Required Date: 2/01/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 13-01-28 Tooling:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4020	A								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D4020 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control	***CUT OUTS WILL BE CUT BY WELDERS WHEN INSTALL ON BASKET***								
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control	***CUT OUTS WILL BE CUT BY WELDERS WHEN INSTALL ON BASKET***								



13-2-6

6

6 0 Jm 13-2-6

6 0 Jm 13-2-6

Work Order ID 96486

January-28-13 2:20:23 PM

96486

Page 2

Item ID: D4020-11

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Item Name: End Mesh, Basket

Stop ***NS2***

Start Date: 1/28/13 Start Qty: 6.00

6

Cust Item ID:

Required Date: 2/01/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: WA 7 0.00

130

Packaging

Memo

0.00

Packaging

CP13-2-19 (6)

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

13/2/20 AG

13-2-20

Picklist Print

January-28-13 2:20:26 PM

Page 1

Work Order ID: 96486

96486

Parent Item: D4020-11

D4020-11

Parent Item Name: End Mesh. Basket

Start Date: 1/28/13

Required Date: 2/01/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: new issue DD 09.11.26 verified by:EC IPP Rev:B as
per dwg revA 10.03.15 verified by:EC IPP Rev:C 10.06.14 remove
cut out from dxf, will be made when install on basket DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304EX0.75-16F

Purchased

No

100

sf

1,296.136

2.694

~~17,014.74~~

M304FX0 75-16F

**

18

Expanded Metal Flat SS

Jm13-26

Location

Loc Qty

Loc Code

WA007

1296.136264

117197

102.9036

120917

50.88673

121521

0.00013372

122080

63.0699

122315

0.395

122534

160

122604

61.238

122884

36.5679

123448

246.09

123855

147.07

124070

107.915



124347

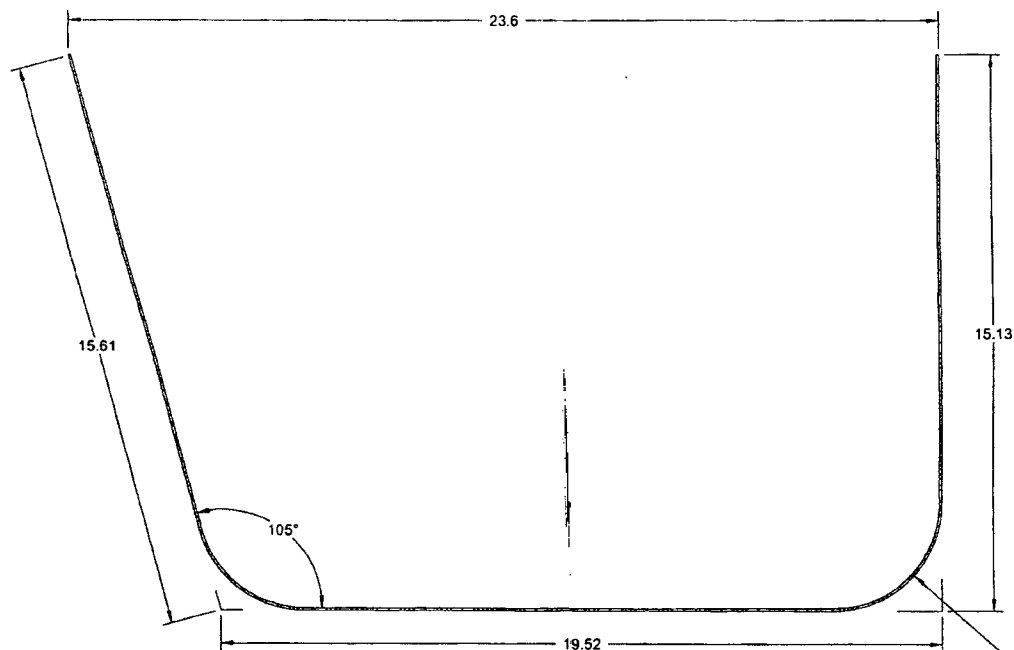
320

124030

~~124347~~

FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	10.04.01	New Issue	KJ	
B	10.08.03	Dimensions updated	KJ 	



SE
K
ENC
UNCON
SUBMIT
V
W
NO. 96486 MJS
13-01-28

9 D4020-1 MESH (350 BASKET LONG, BASE)
(SEE D4020-1F FOR LENGTH)

9 D4020-3 (350 BASKET SHORT, BASE)
(SEE D4020-3F FOR LENGTH)

R3.0
TYP

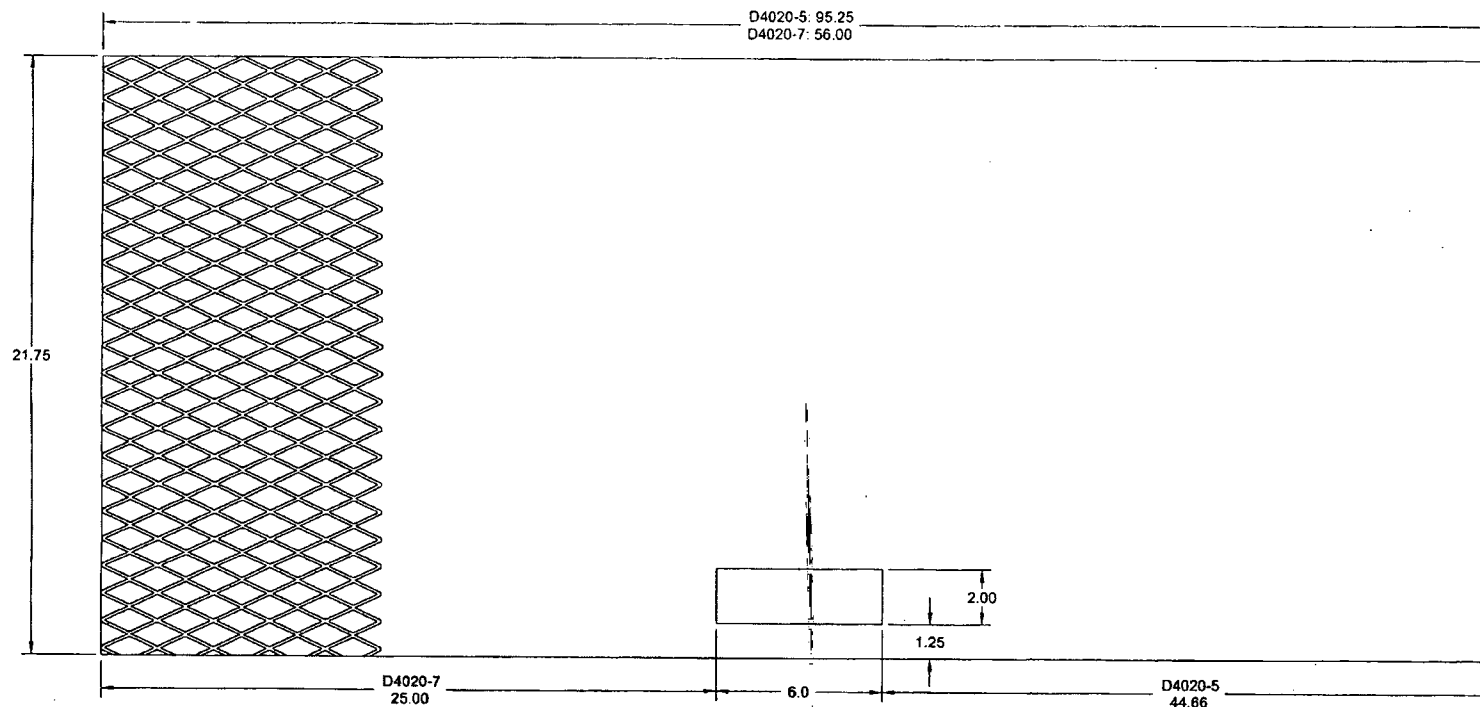
RELEASED
2010-03-12
WJ

NOTES:

- 1) MATERIAL-1: MAKE FROM D4020-1F
-3: MAKE FROM D4020-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE D4020-1F & D4020-3F
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) PRE-FORMING OF MESH PER SHOP OPTION, THIS VIEW MAY BE USED FOR REF ONLY

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	W	DRAWING NO.	REV. A
MFG. APPR.	E	D4020	SHEET 1 OF 4
APPROVED	W	TITLE	SCALE
DE APPR.	W	350 BASKET MESH (BASE)	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

96486



9 D4020-5 MESH (350 BASKET LONG, LID)
(LOCAL SECTION MESH SHOWN FOR CLARITY)

9 D4020-7 MESH (350 BASKET SHORT, LID)
(LOCAL SECTION MESH SHOWN FOR CLARITY)

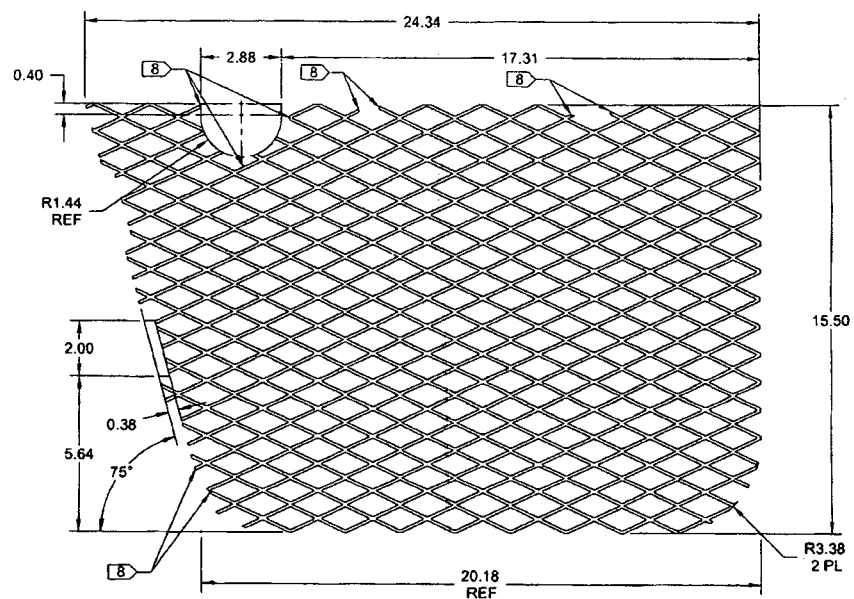
NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -5: 0.80 lbs APPROX
-7: 4.49 lbs APPROX
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

RELEASED
2010-03-12
ND

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. A
MFG. APPR.	JP	D4020	SHEET 2 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	350 BASKET MESH (BASE)	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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96486



9 D4020-11 END MESH, BASKET

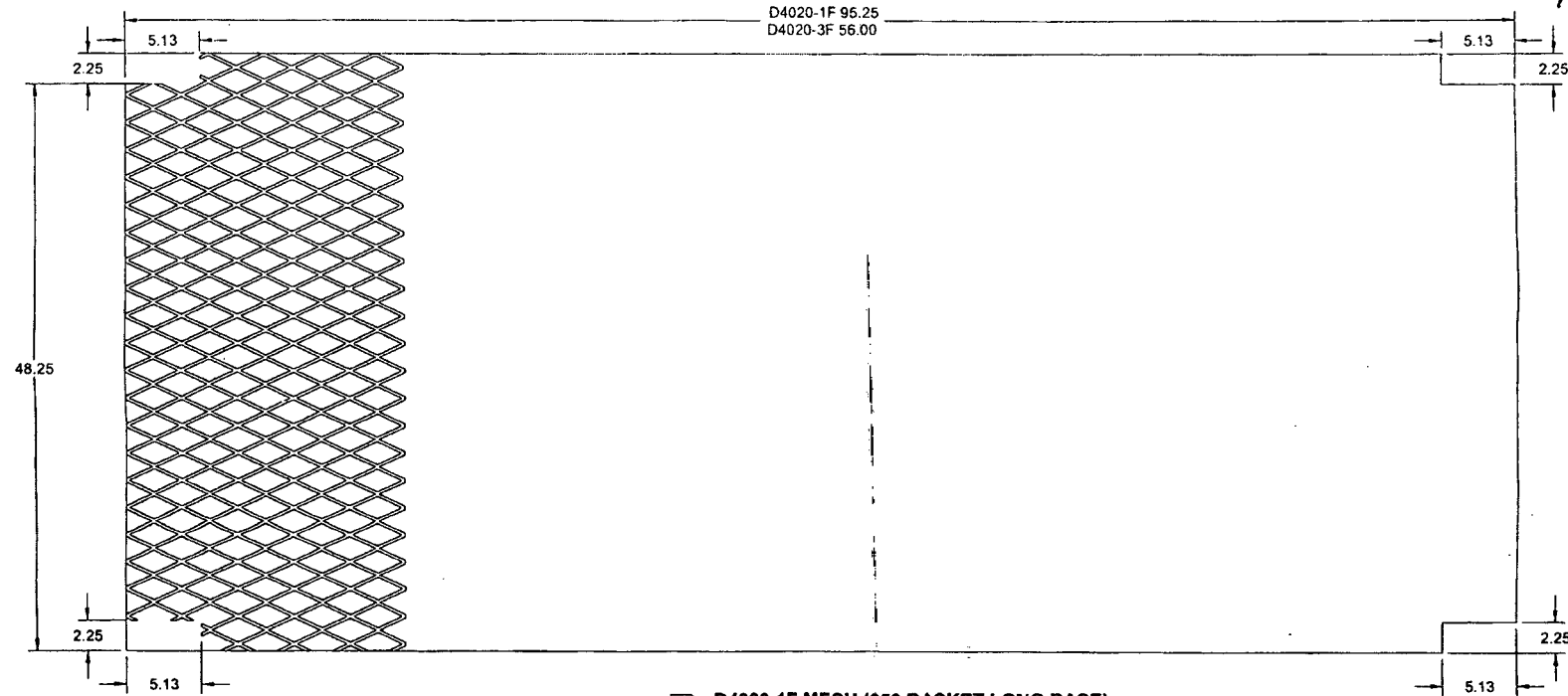
NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.22 lbs
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

RELEASED
2010-03-12
JMD

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4020	REV. A SHEET 3 OF 4
MFG. APPR.	<i>[Signature]</i>	TITLE 350 BASKET MESH (BASE)	SCALE NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.03.04		

96486



D4020-1F MESH (350 BASKET LONG BASE)
(LOCAL SECTION MESH SHOWN FOR CLARITY)

D4020-3F MESH (350 BASKET SHORT, BASE)
(LOCAL SECTION MESH SHOWN FOR CLARITY)

RELEASED
2010-03-13
MP

- NOTES:**
- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT -1F: 17.33 lbs APPROX
-3F: 10.16 lbs APPROX
 - 8) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4020	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 BASKET MESH (BASE)	NTS
DATE	10.03.04	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMING OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Receiving Report

Date: 12/12/19
 Supplier: ULBRICH

Batch No: M124070
 Part P/O: 18620

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☒ No ☐ N/A ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection LOAS N/A ☒
 Work Order 16 N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Production/Admin: 12/12/19
 Date
 Received/Costing
 Initial

Location _____

Wednesday, December 19, 2012 1:59:34 PM

All Item ID/GL/WOs All Rec. Employees All Currencies

Grouped by Vendor ID

Total Received Quantity:	320.0000
Total Qty to Inspect (PO U/M):	0.0000
Total Reject Quantity:	0.0000
Total Receipt Value:	\$1,623.14
Total Balance Due Quantity:	0.0000



SOLD TO:
00022279

DART AEROSPACE LTD
1270, ABERDEEN STREET
HAWKESBURY, ON K6A 1K7

Diversified Ulbrich
20 Hymus Blvd
PTE. Claire, QC H9R 1C9,
Phone: (514)694-6522 Fax : (514)694-0266
Toll Free: (800)361-5950
SHIP TO:

DART AEROSPACE LTD
1270, ABERDEEN STREET
HAWKESBURY, ON K6A 1K7

PACKING LIST.

Page: 1

I048549

SPECIAL INSTRUCTIONS

SHIP TST GROUND COLLECT

Contact: CHANTAL LAVOIE

Ship Terms: COLLECT

MTR:Y

Currency	Sales Person	Customer Phone	Customer Fax	Customer PO
CANADIAN DOLLARS	BOB MESSETT	(613) 632-5200	(613) 632-4443	PO18620

Sales Order	Terms	Ship Via	Date Ordered	Date Required	Date Shipped
W231527	NET 30 DAYS	COMMON CARRIER	12/17/12	12/18/12	12/18/12

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
10		PC	SSH T-304 EXP PAPER 16F x 3/4" x 48" 180 LB / 10 PC S/C INCLUDED IN PRICE MTR'S WITH SHIPMENT****MTR'S WITH SHIPMENT*** 1 PALETTE CERT D'ANALYSE	L025818	A5M7	10
Approx Weight: 180.0 LB 12/18/12 11:52:58						

Received by:

Date:

Signature:



NA-3T ASM 7, PDF

METALLURGICAL TEST REPORT

NORTH AMERICAN STAINLESS
6870 HIGHWAY 42 EAST
GHENT, KY 41045

6870 HIGHWAY 42 EAST

Certificate: 705682 1
Customer: 007040 001
Mail To:
ULBRICH OF CANADA
98 NORFINCH DRIVE
DOWNSVIEW, ON M3N1X1Ship To:
ULBRICH OF CANADA
98 NORFINCH DRIVE
DOWNSVIEW, ON M3N1X1

Date: 1/25/2012 Page: 1

Steel: 304/304L

Finish: 2B

Your Order: P001562

NAS Order: WN 0028478 01

Corrosion: ASTM A262/02aE, 180Bend-OK

PRODUCT DESCRIPTION:

STAINL STEEL COIL, C.R. ANNEALED & PICKLED; UNS 30400/30403
EN10028-7 & EN10088-2, 1.4301/1.4307
ASTM A240/10, A480/10, A586/10; ASME SA240/10, SA480/10, SA666/10
ANSI/ASME B56.1/10, MIL-S-5059D AND 1(X CRN MEAS); MIL-S-4043B
FACE MR0175/01, MR0103/07; Q08766D-A X MAG FERM
MIN. SOLUTION ANNEAL TEMP 1900F, WATER QUENCHED

REMARKS:

Mat'l is Free of Mercury Contamination. No weld repairs.
EN 10204:2004 3.1; Q08763F Cond A; RoHS Compliant
Material is Free of Radioactive Contamination
NAS Steel Making Process: EAF, AOD, & Cont. Casting
Product Mfg. by a Quality Mgt. Sys. in Conf. w/ISO 9001
*Melted & Manufactured in the USA; Mat'l is DPA's Compliant

Product Id	Coil #	Skid # Thickness	Width	Weight	Length	Mark	Pieces	Commodity Code
02ASM7 AA	02ASM7 A	.0575	48.0000	3,900	SHEETS	096.00	50	

CHEMICAL ANALYSIS CM(Country of Melt) ES(Spain) US(United States) ZA(South Africa) JP(Japan)

HEAT	CM	C	CR	CU	MM	MO	N	NI	P	S
ASM7	US	.0290	18.4045	.4310	1.7660	.3190	.0558	8.0565	.0310	.0013
		SI								
		.2495								

MECHANICAL PROPERTIES

Product Id#	Coil #	1 d	UTS	.2% YS	1% YS	ELONG	Hard	Tail
		o 1	KSI	KSI	KSI	%-2"	RB	Hard
02ASM7 AA	02ASM7 A	F T	94.29	46.27	54.84	45.45	86.50	84.50

NAS hereby certifies that the analysis on this certification is correct and the material meets the specifications stated.

Technical Dept. Mgr.

ERIC HESS

1/25/2012



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO18620

Purchase Order Date 12/11/12

PO Print Date 12/11/12

Page Number 1 of 1

Order From :

DIVERSIFIED ULBRICH
20 HYMUS BLV
POINTE-CLAIRE, QC H9R 1C9
CA

VC-DIV001

Contact Name

Vendor Phone 514 694 6522

Vendor Fax 514 694 0266

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED
8/12/12

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M304EX0.75-16F	Expanded Metal Flat SS	12/19/12 Yes	320.00 sf	TST ground	\$5.0400	\$1,612.80

Special Inst:

AISI 304/316 STAINLESS STEEL
EXPANDED METAL MESH PER ASTM
A240
PER ASTM F1267 OR MIL-M-17194

12/11/12

PO Total:

\$1,612.80

**MATERIAL CERTIFICATION
REQ'D UPON DELIVERY**

Change Nbr: 1

Change Date: 12/11/12

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required **YES** NO